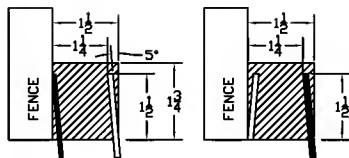
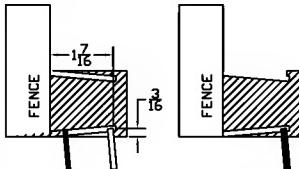


# HOW TO MAKE A DOUBLE SIDED BOX CALL FROM A SOLID BLOCK OF WOOD



Square your wood up to  $1\frac{1}{2}$ " x  $1\frac{3}{4}$ " x  $7\frac{1}{2}$ " long. Set the table saw blade to a 5 degree angle toward the fence, and a height of  $1\frac{1}{2}$ ". Adjust the fence to a distance of  $1\frac{1}{4}$ " from the tip of the blade. Cut a slot in each side of the block as shown to the left.

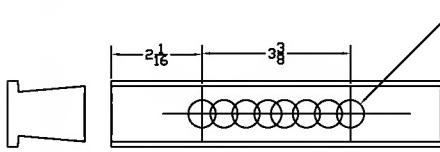
Be sure the grain runs at an angle or straight across, not up and down.



Do not change the angle on the blade, but lower it to a height of  $\frac{3}{16}$ ". Adjust the fence to a distance just slightly less than  $1\frac{1}{2}$ ". Now make the cuts as shown to the left.

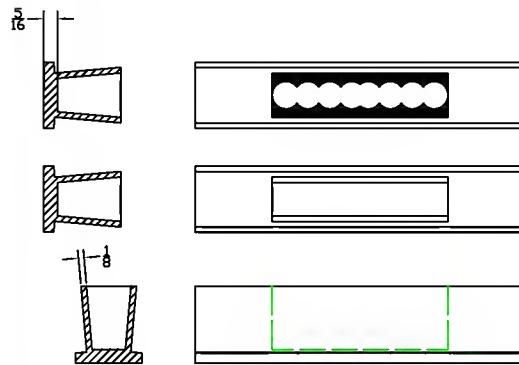


A small nib will be left on the top of the call base. Sand this off. With some practice you can cut this very close, reducing the amount of sanding required.

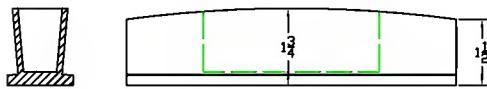


Mark a center line on the top of the call and cross mark at the dimensions shown.

Using a  $5/8$ " forstner bit, drill at the intersection of the lines and progressively every  $1/2$ " or so along the center line to rough out the opening in the body. Set your drill stop so that  $5/16$ " is left in the bottom of the call body.



Using a sharp chisel remove the excess material along the sides of the call. Be sure to follow the 5 degree angle on the outside of the call sides. A small ( $1/2$ ") drum sanding mandrel can also be used to clean up much of this. Finish by sanding chisel marks out.



You should know how the basic shape shown at the left. The thickness of the sides should be about  $1/8$ " or a little more.

Mark the top curve on the sides of the call. The height of the curve should be  $1\frac{1}{2}$ " at the ends and  $1\frac{3}{4}$ " on the center.

This curve can be cut on a band saw or sanded. If you use a band saw, finish by sanding so that both sides have the same exact shape.



Now, using a half round file, file the both ends of the call as shown to the left. This is required to keep the lid from dragging at the ends. The depth of this cut should be about  $1/8$ " at the deepest point.

Select which end of the call you want to hinge the lid to. Most calls are oriented so that the grain is going up to the right when looking at the back of the call. Mark and drill a  $3/8$ " diameter spring seat approximately  $1/4$ " deep at a distance  $3/4$ " from the end of the call. Next, drill a  $3/32$ " screw hole about  $1$ " deep.

At this point the basic machining of the call body is complete.